



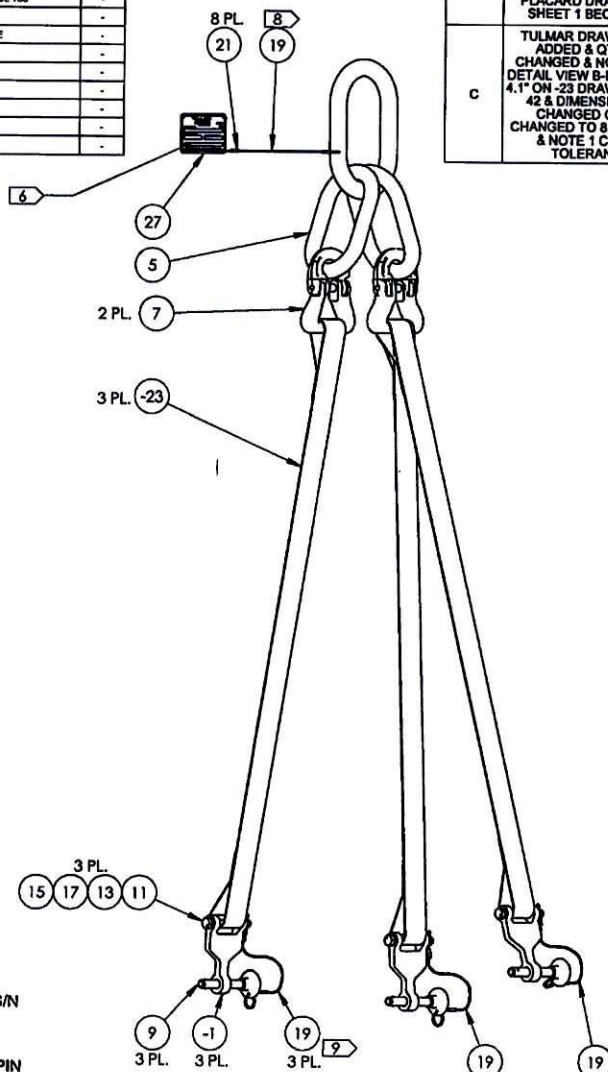
Ship Via:



ITEM #	QTY	PART #	TITLE	PG
-1	3	RBEM623U1002102-1	LIFTING CLEVIS	2
-23	3	RBEM623U1002102-23	STRAP ASSY	3
27	1	RB41011	DART PLACARD	-
5	1	McMaster#7163T12	OBLONG LINK W/COUPLINGS LINKS 7/8" GRADE 100	-
7	3	PEWAG#CARW 10 OR CROSBY 5-237#10206FS	SLING CONNECTOR	-
9	3	McMaster#909854335	QUICK RELEASE PIN 7/16" x 2-1/2" USABLE	-
11	3	SPENCER AIRCRAFT# AN5-27	HEX HEAD CAP SCREW	-
13	6	SPENCER AIRCRAFT# AN960-316	FLAT WASHER	-
15	3	SPENCER AIRCRAFT# AN310-5	CASTLE NUT	-
17	3	McMaster#98338A175	COTTER PIN 1/8" x 3/4"	-
19	A/R	CARR LANE#CL-2-C	NYLON COATED WIRE 1/16"	-
21	8	McMaster#3899331	FERRULE 1/16" DIA. x 3/8"	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASE FOR PRODUCTION	-	1/7/2016	RJC	JAG
B	ITEM# -23 ASSY ADDED, MATERIAL SPECIFICATION ADDED TO ITEM# -3, TEMPLATE UPDATED, ITEM# -25 ADDED, WEIGHT TEST DRAWING ADDED ON SHEET 7, PLACARD DRAWING ADDED ON SHEET 6, NOTE 3 ON SHEET 1 BECOME NOTE 7 AND TYPO CORRECTED	17-702	17.10.06	VM	WM
C	TULMAR DRAWING'S MARKUPS ADDED; TULMAR P/N ADDED & QTY OF -25 CHANGED TO 4 & NOTE 10 CHANGED & NOTE 11 ADDED & SECTION A-A ADDED & DETAIL VIEW B-B ADDED & LENGTH OF -25 INCREASE TO 4.1" ON -23 DRAWING, DIMENSION OF 44.9 DECREASE TO 42 & DIMENSION OF .06 CHANGED TO .05 & NOTE 1 CHANGED ON -3 DRAWING, DIMENSION OF 12.5 CHANGED TO 8.75 & DIMENSION OF .2 CHANGED TO .05 & NOTE 1 CHANGED ON -25 DRAWING, TULMAR TOLERANCE ADDED, -26 DRAWING ADDED	17-756	17.11.22	VM	WM

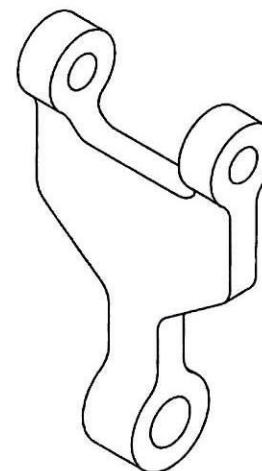
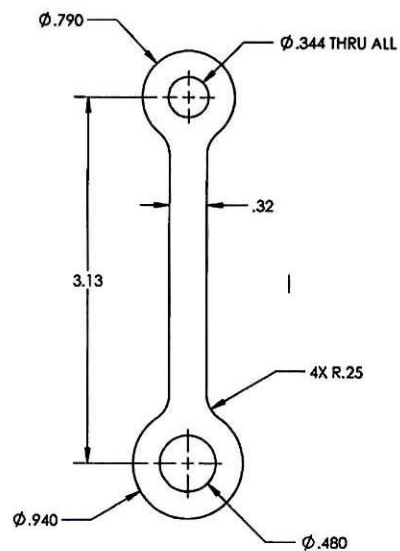
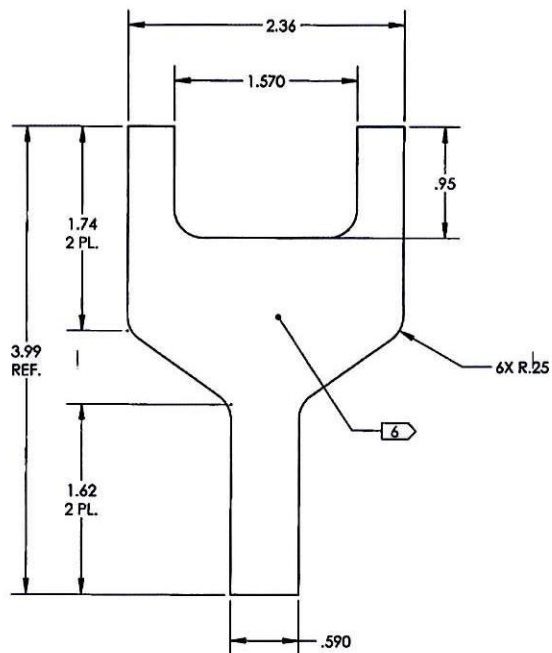
RBEM623U1002102 SWASHPLATE SLING



- NOTES:**
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: ENGRAVE "SWL 75 LBS, LOAD TESTED 90 LBS" & P/N & S/N WHERE INDICATED
 - 7) REF. AIRBUS T/N M632U1002102
 - 8) ATTACH ITEM# 19 LANYARD TO ITEM# 5 AND ITEM #27 DART PLACARD
 - 9) ATTACH ITEM# 19 LANYARD TO -17 COTTER PIN AND -9 QUICK RELEASE PIN

SEE ATTACHED DEVIATION

DART AEROSPACE Huntsbury, Ontario, Canada		TITLE	
		SWASHPLATE SLING	
DWS NO.		REV	
RBEM623U1002102		C	
DESIGN BY:	VM 10/8/2017	30X 2 300	FRACTIONS & 1/8"
DRAWN BY:	VM 11/28/2017	3X 2 1	ANGLES & 5°
CHECKED:	VM 11/28/2017	SURFACES = 125	
MFG. APPR:	DP 11/29/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	VM 11/29/2017	2. DEVELOPMENT DIM AND TOL PER ASME Y14.5M-2009	
DATE:	1/28/2017	3. DIMENSIONAL LIMITS APPLY	
SCALE:	NTS	WEIGHT:	N/A
		SHEET 1 OF 7	
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RBEM623U1002102-1 LIFTING CLEVIS

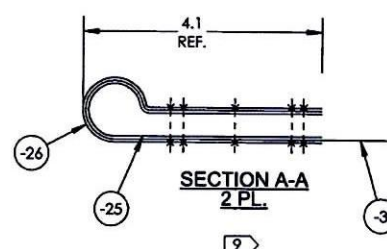
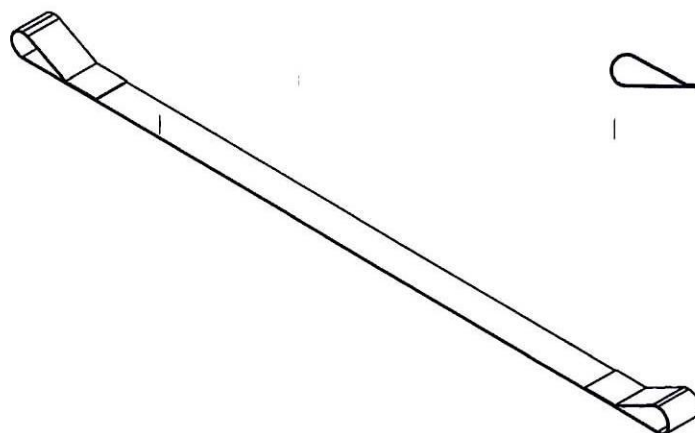
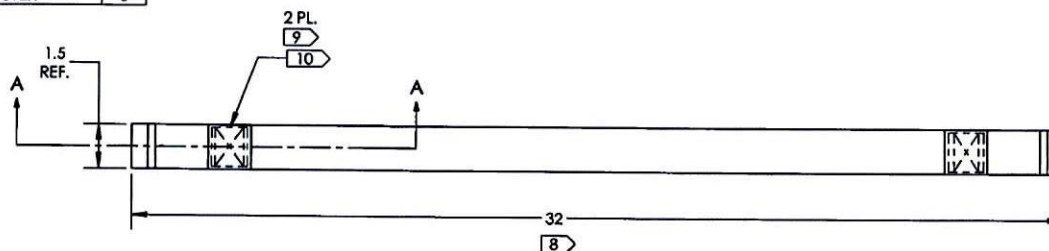
NOTES:

- 1) MATERIAL: AISI 1018/1020 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDER COAT YELLOW PROTECH# HS112Y12
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: INK STAMP P/N

SEE ATTACHED DEVIATION

DART AEROSPACE		Hawkebury, Ontario, Canada	
TITLE LIFTING CLEVIS			
DWG NO.	RBEM623U1002102-1		REV C
DESIGN BY:	WM 10/8/2017	.XXX ± .005 FRACTIONS ± 1/8	ANGLES & 8° SURFACES ± 15°
DRAWN BY:	WM 11/28/2017	.XX ± .01	
CHECKED:	WM 11/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
MFG. APPR:	WM 11/28/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED:	WM 11/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DATE:	11/28/2017	SCALE: NTS	WEIGHT: 0.485 LBS
		SHEET 2 OF 7	
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ITEM #	QTY	PART #	TITLE	PG
-3	1	RBEM623U1002102-3	STRAP	4
-25	2	RBEM623U1002102-25	WEB SLING PROTECTORS INNER	5
-26	2	RBEM623U1002102-26	WEB SLING PROTECTORS OUTER	6



TOLERANCES	
+/- .125"	< 2"
+/- .250"	2 TO < 10"
+/- .500"	10 TO < 20"
+/- .625"	20 TO < 40"
+/- 1.5%	= OR > 40"
+/- 5°	ON ALL ANGLES

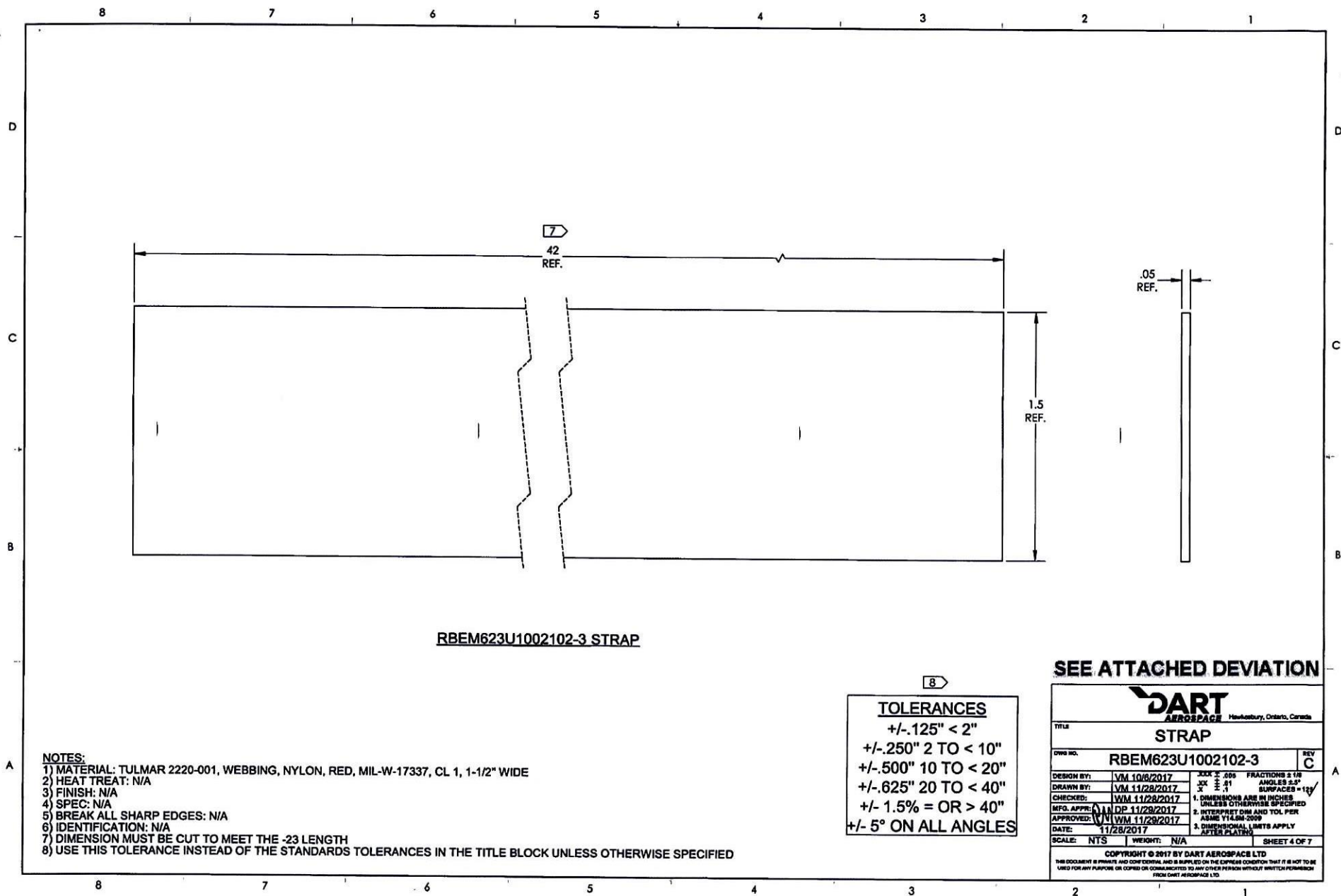
SEE ATTACHED DEVIATION

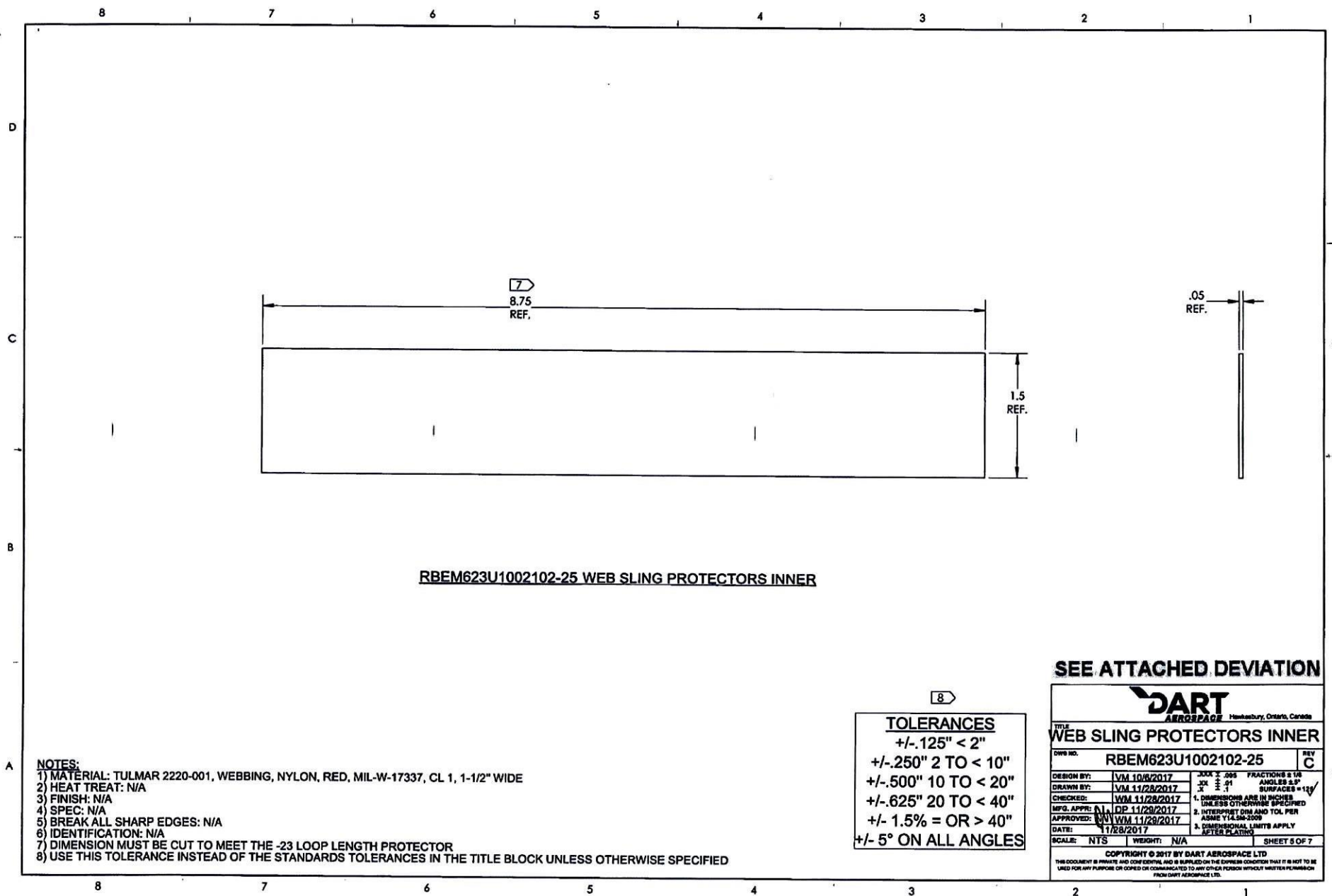
NOTES:

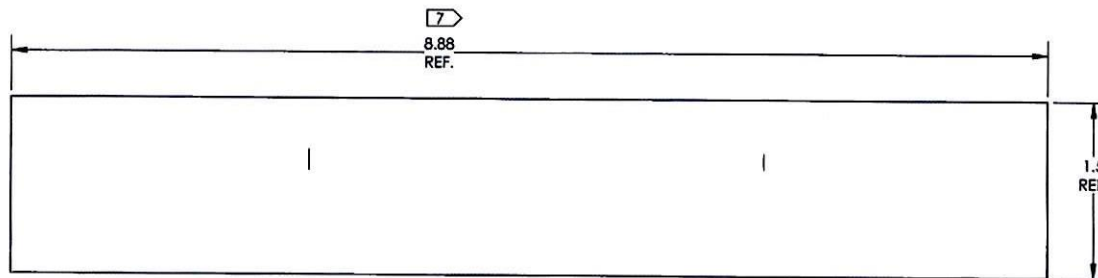
- 1) MATERIAL: RBEM623U1002102-23 STRAP ASSY SUPPLIED BY TULMAR 87345-001
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) SAFETY CERTIFICATE REQUIRED FOR SWL OF 75 LBS
- 8) FINAL LENGTH OF SEWN STRAP
- 9) USE TULMAR 2544, THREAD, NYLON, RED, A-A-59826, TY2, CLA, SIZE F, FOR ALL SEWING
- 10) 1-1/4 x 1-1/4 FLAG
- 11) USE THIS TOLERANCE INSTEAD OF THE STANDARDS TOLERANCES IN THE TITLE BLOCK UNLESS OTHERWISE SPECIFIED

RBEM623U1002102-23 STRAP ASSY

DART AEROSPACE Hawkebury, Ontario, Canada	
TITLE STRAP ASSY	
DWG NO. RBEM623U1002102-23	REV C
DESIGN BY: VM 10/8/2017	300 ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 11/28/2017	XX ± .01 ANGLES ± 5°
CHECKED BY: VM 11/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
MPG APPR: VM 11/28/2017	2. RETYPSET DIM AND TOL PER ASME Y14.5M-2009
APPROVED BY: VM 11/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DATE: 11/28/2017	
SCALE: NTS	WEIGHT: N/A
SHEET 3 OF 7	
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RBEM623U1002102-26 WEB SLING PROTECTORS OUTER

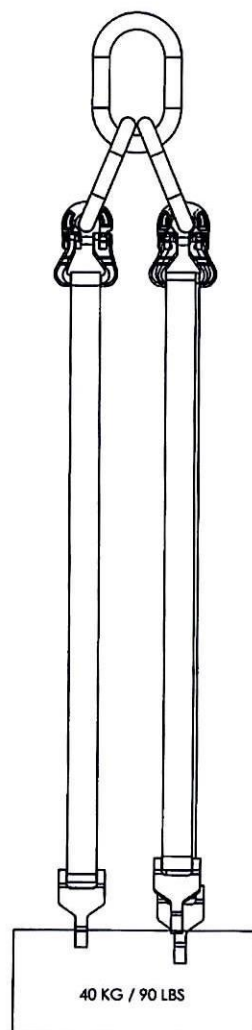
NOTES:

- 1) MATERIAL: TULMAR 2220-001, WEBBING, NYLON, RED, MIL-W-17337, CL 1, 1-1/2" WIDE
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) DIMENSION MUST BE CUT TO MEET THE -23 LOOP LENGTH PROTECTOR
- 8) USE THIS TOLERANCE INSTEAD OF THE STANDARDS TOLERANCES IN THE TITLE BLOCK UNLESS OTHERWISE SPECIFIED

TOLERANCES	
+/- .125"	< 2"
+/- .250"	2 TO < 10"
+/- .500"	10 TO < 20"
+/- .625"	20 TO < 40"
+/- 1.5%	= OR > 40"
+/- 5° ON ALL ANGLES	

SEE ATTACHED DEVIATION

TITLE WEB SLING PROTECTORS OUTER			
DWG NO. RBEM623U1002102-26		REV C	
DESIGN BY: VM 10/8/2017	CHECKED BY: VM 11/28/2017	DATE: 11/28/2017	SCALE: NTS
APPROVED BY: VM 11/28/2017		WEIGHT: N/A	
DATE: 11/28/2017			
SCALE: NTS			
WEIGHT: N/A			
SHEET 8 OF 7			
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INSPECTION & TESTING PROCEDURES FOR THE RBEM623U1002102, UPPER STOPS AND FAIRING SLING. THIS SLING IS DESIGNED FOR HOISTING AND INSTALLING/REMOVING THE H175 COWLING.
THIS SLING ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE.
REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT TEST WEIGHT OF 40Kg / 90 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGED/FRAYED STRAPS.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, DISTORTIONS OR DAMAGED/FRAYED STRAPS.

INSPECTOR: _____

TESTER: _____

S.N.: _____

DATE: _____

SEE ATTACHED DEVIATION

DART AEROSPACE Hawkebury, Ontario, Canada			
TITLE SWASHPLATE SLING			
DWS NO. RBEM623U1002102			REV C
DESIGN BY:	VM 10/8/2017	JOCK X .005 FRACTIONS 5/16	✓ ANGLES 2.5° SURFACES # 125
DRAWN BY:	VM 11/28/2017	X 2 .01	
CHECKED:	WM 11/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
MFG. APPR:	DP 11/29/2017	2. INTERPRET DIM AND TOL PER ASME Y14.3M-2009	
APPROVED:	WM 11/29/2017	3. DIMENSIONAL LIMITS APPLY SEEN PLATING	
DATE:	11/28/2017		
SCALE:	NTS	WEIGHT:	N/A
			SHEET 7 OF 7
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBEM623U1002102 Rev. C</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval May 4, 2018		
Description Work Order Deviation				Disposition				Completed By	
McMaster Carr Cotter Pin 98338A175 must be replaced with MS24665-134 Cotter Pin				- This deviation is acceptable. - The fit, form and function of the part will be as originally intended.					
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
				OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040832

Supplier: TUL001-VC
Tulmar Safety Systems
1123 Cameron St
Hawkesbury
ON
K6A 2B8 Canada
Phone: 613 632 1282
Fax: 613 632 2030

PO No: PO040832
PO Date: 8/23/18
Due Date: 9/13/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lussier, Patrick

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: *Revision*

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181896	RBEM651V3000125-3P			Strap Assembly	Firmed	-	9/20/18	7 Ea	0 Ea	7 Ea	\$21.28/Ea	\$148.96
Line Item Note Will bring the RBEM651V3000125-1 ASAP Ok to manufacture with Mark-ups Tulmar provided													
3	182404	RBEM623U1002102-23P			Strap Assembly	Firmed	-	9/20/18	15 pcs	0 pcs	15 pcs	\$50.00/pcs	\$750.00
Grand Total:													\$898.96

DAS
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9-89

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/18 10:09 AM dart.Lussier.Patrick

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

64411 1

Ship Date

9/12/2018

Bill To:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Order number	Sales order date	Account number	Loc	Account manager	Shipping Terms	
36359	8/24/2018	CDART100	H	Vicky Eve Lovvorn	FOB ORIGIN	
PO number	Ship via	Item No.	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order
040832 ✓	Pick-Up	Description				
87345-001		Strap Assy	15.00 ✓	EA	15.00	
Drawing No: RBEM623U1002102-23 ✓						
DWG Rev: C						
RBEM623U1002102-23P						
SF=45967						
Lot no.: BATCH0000000002			15.00			

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Certificate of Conformance

☐ See Certification Enclosed

I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 225.

Authorized Inspector

Jessie - Lee Lacombe

Date:

SEP 12 2018